



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-748-203
Job Sheet 184901



Part No: D350-748-203

Job Qty: 1 ea

Part Name: AS350 / AS355 Stainless Steel Aft Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D350-748-243 REV:A IPP REV:A 15.03.23 NEW ISSUE DD VERF:JLM

Ship Via:

08067

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Crosstubes-1		GP 19-01-15
110	CNC Bend Crosstubes	1 pcs	11/16/18	11/16/18	5.40	2.44	CNC Bend Crosstube		GP 19-01-15
120	Crosstubes	1 pcs	11/16/18	11/16/18	0.00	2.19	Crosstubes-2		GP 19-01-15
127	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC15		38
128	Crosstubes	1 pcs	11/16/18	11/16/18	0.00	1.98	Crosstubes-2		BB 19-01-21
130	Crosstubes	1 pcs	11/16/18	11/16/18	0.00	2.89	Crosstubes-2		BB 19-01-21
140	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC5		38
174	Outsource	1 pcs	11/16/18	11/16/18			SKY002-VC		CT 19-01-25
176	Packaging	1 pcs	11/16/18	11/16/18	0.00	0.00	Packaging2		JAN 30 2019
178	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC6		38
180	SprayPaint	1 pcs	11/16/18	11/16/18	0.00	1.07	Spray Paint		R.D. 19-01-31
190	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC14		AB 19-2-5
200	Crosstubes	1 pcs	11/16/18	11/16/18	0.00	2.89	Crosstubes-2		R.D. 19-2-6
210	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC5		PD 19-02-11
220	Packaging	1 pcs	11/16/18	11/16/18	0.00	0.00	Packaging1-3		2019 FEB 12 2019
230	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC4		2019 FEB 13 2019
240	Packaging	1 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-1		2019 FEB 13 2019
245	DC	1 pcs	11/16/18	11/16/18	0.00	0.00	DC		2019 FEB 13 2019
250	QC21-FG	1 Ea	11/16/18	11/16/18	0.00	0.00	QC21		2019 FEB 13 2019

Part Op 110 - Bend tube as per Dwg D350-748-243 using CNC bender program D350A and Folio FT ***** UNDER

Descriptions: BEND .225" PER SIDE***** USE (4) DT9824 SHIM BLOC TO CHECK STRAIGHTNESS****

120 - ****VERIFY CROSSTUBE DIMENSIONS AS PER DWG****

127 - ***MARK CUT LINES***

128 - CUT TUBE AT HEIGHT ON FAI SHEET VERF HEIGHT _____ BY QC 15 LEVEL INSPECTOR

130 - 1- Drill Tube as per Dwg D350-748-243 Using DT8876 Drill Jigs, set-up drill table as per QSI 010. 2-Deburr 3- Engrave Part # and Batch # as per Dwg D350-748-243 4- Remove all marks from tube within limits of D350-748-243

174 - ISSUE P/O TO SKY SERVICE: DOO42383

180 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1. Apply Axalta 13205S Cleaner inside and outside crosstube per QSI 005 4.1.4 BATCH: 133949 2.

Axalta 230S Metalok inside and outside crosstube per QSI 005 4.1.4 BATCH: M134021 3. Prime inside and outside crosstube per QSI 005 4.2 BATCH: S143304 4. Paint outside of crosstube per QSI 005 4.2 BATCH: S146086

190 - Then,Wrap in plastic bag to protect from scratches ***VERIFY BY _____ BATCH # TO MATCH W/O

200 - INSTALL GROUND WIRE INSERT, THEN INSERT SCREW AND WASHER ***LIMIT AIR PRESSURE TO 50 PSI WHEN INSTALLING AETC-1032 INSERT AND ONLY EXPAND INSERT ONCE*** 1-Abraze mating surfaces of support

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2-Install supports with Proseal 890 per D350-748-243 and QSI 015 A/R Proseal 890 Batch: 189976 EXP: 6/19 3-Install supports clamps Using Dt8876 as per Dwg D350-748-243, Torque to 60-80 IN-LBS. PROSEAL CURE TIME 72 HOURS: Start: 19-2-6 Finish: 19-2-9

210 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

***VERIFY BY _____ BATCH # TO MATCH W/O _____

230 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

240 - Identify and pack for shipping as per PPPD350-748-203 Location: _____ PPP Rev: _____

245 - Photocopy bluefile & type labels per PPPD350-748-203 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D350-748-243TRN	Crosstube Installation, High Aft	1 Ea (1 ea)	90-Start up Operation	.. 157.
AETC-1032	Insert	1 Ea (1 ea)	200-Crosstubes	
D3502-1	Support	2 Ea (2 ea)	200-Crosstubes	
D5123-7	Clamp Cushion	2 Ea (2 ea)	200-Crosstubes	
MS21920-20	Clamp	2 Ea (2 ea)	200-Crosstubes	
NAS1149C0363R	Washer	1 Ea (1 ea)	200-Crosstubes	
MS51958-63	Screw	1 pcs (1 ea)	200-Crosstubes	
AN4-41A	Bolt	8 Ea (8 ea)	220-Packaging	5058981
AN4-6A	Bolt	16 Ea (16 ea)	220-Packaging	5053945 5074205 54
AN5-32A	Bolt	4 Ea (4 ea)	220-Packaging	5058983
D3500-1	Saddle	4 Ea (4 ea)	220-Packaging	5105264
D3501-1	Bushing	16 Ea (16 ea)	220-Packaging	5128748
MS21042L4	Nut	24 Ea (24 ea)	220-Packaging	5199814
MS21042L5	Nut	4 Ea (4 ea)	220-Packaging	5093592
MS51958-63	Screw	1 pcs (1 ea)	220-Packaging	
NAS1149D0463J	Washer	32 Ea (32 ea)	220-Packaging	5150216
NAS1149D0563J	Washer	8 Ea (8 ea)	220-Packaging	5139756 5123452 54

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D350-748-243TRN	1	4	0
200-Crosstubes	AETC-1032	① FM137335	233	0
	D3502-1	② 5089362	38	0
	D5123-7	② 5074321	301	0
	MS21920-20	② 5083554	200	0
	MS51958-63	① FM134962	63	0
	NAS1149C0363R	① 5132615	309	0
220-Packaging	AN4-41A	8 5058981	487	0
	AN4-6A	16	1,038	0
	AN5-32A	4	314	0
	D3500-1	4	63	0
	D3501-1	16	264	0
	MS21042L4	24	4,133	0
	MS21042L5	4	685	0
	MS51958-63	1	63	0
	NAS1149D0463J	32	4,955	0
	NAS1149D0563J	8	1,318	0

Part Specifications

DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

e found.

Container No: S144869



Part: D350-748-203

Job No: 184901

Serial No/Batch: S144869

Revision: A

Inspector:

Exp Date:

Instructions: TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA S

Plex 10/17/18 3:10 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

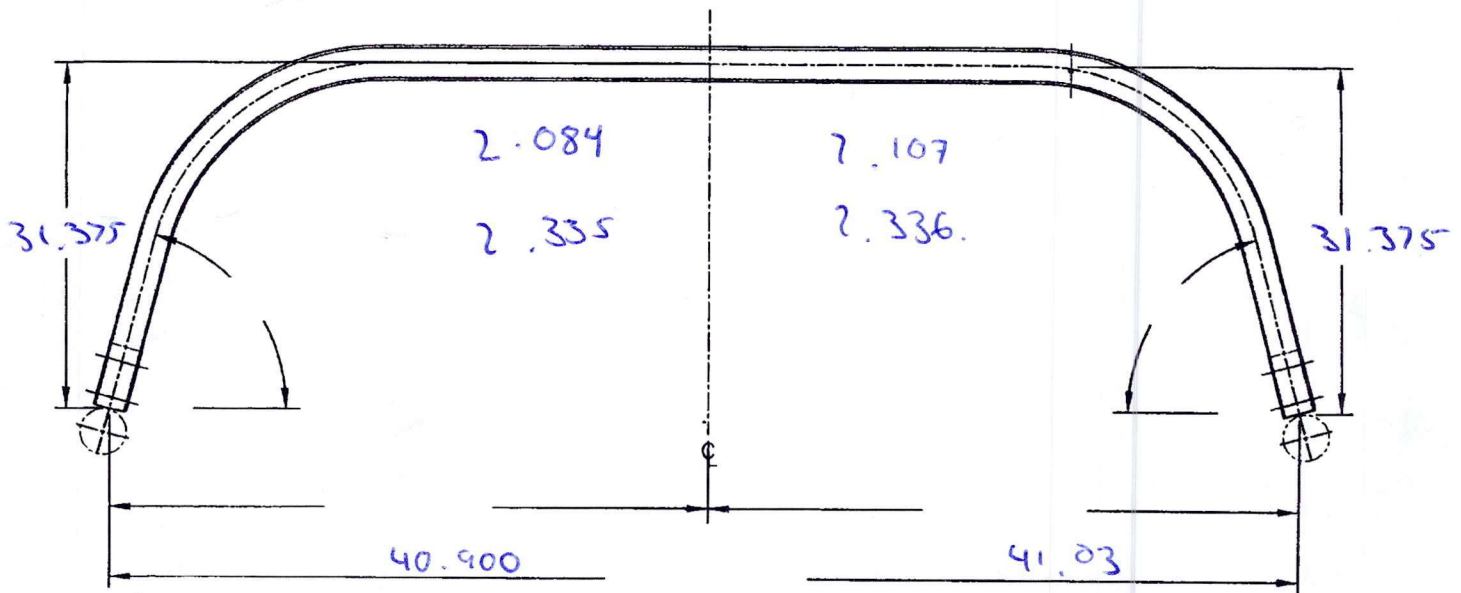
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order:	184901
Description: Crosstube High Aft, SS (AS350/355)		Part Number:	D350-748-203
Inspection Dwg: D350-748-243 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	31.10	31.60
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06
Bending Passes	7	--
Crushing	--	8%
Twist	--	0.38



	Side A	Side B
Bending Passes		
Crushing	5.7%	5.1%
Comments		

QC15 Inspection	26
Date	19-01-15

Rev	Date	Change	Revised by	Approved
A	15.09.09	New Issue	KJ	

Item	Qty -243	Part Number	Description
1	X	D350-748-243	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6021-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D5123-7	CLAMP CUSHION
5	1	AETC-1032	INSERT
6	2	MS21920-20 OR MS21920-21/-22	CLAMP (PER DART SPEC. M-MS21920-20/-21/-22)
7	1	NAS1149C0363R	WASHER (OR AN960C10)
8	1	NAS1635-3-8	SCREW (OR MS51958-63)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6021-125
FINISHED LENGTH AFTER TURNING = 124.70±0.06 (AFTER BENDING/TRIMMING = 122.70 REF)
- FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCE: PER DART QSI 018 UNLESS OTHERWISE NOTED.
WALL THICKNESS ECCENTRICITY PER DART QSI 038 7.2
MIN. ALLOWABLE WALL IS -0.020 FROM NOMINAL
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: DART PART NUMBER "D350-748-243" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- WEIGHT: 29.85 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.290 HOLE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.

TURNING

- BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.

BENDING

- BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES PER SIDE. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D. ON TOP HALF OF BEND, AND 8% ON BOTTOM HALF OF BEND.
- MAX AMPLITUDE OF RIPPING ALONG BENT PORTION OF THE TUBE IS 0.030 (ZN A1-3)
- MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.38 (ZN C1-3).

ASSEMBLY

- TO INSTALL D3502-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.02" TO 0.05" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- TORQUE CLAMPS 80 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 184901 HLT
18-10-17

DEO ATTACHED

RELEASED

2015 MAR 18

RELEASED

2015 MAR 18

UNDER REVIEW

15/19/15
LRF 15/3/15
16/2/15

A	NEW ISSUE	CP	15.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	15.01.21		

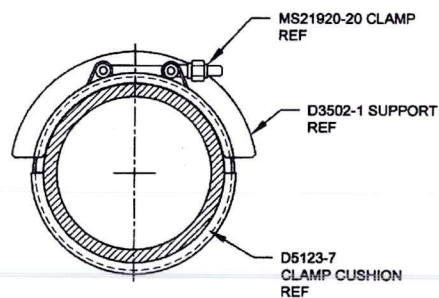
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D350-748-243
REV. A
SHEET 1 OF 4

TITLE CROSSTUBE (AS 350/355 HI AFT)
SCALE NTS

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**D350-748-243
ASSEMBLY DETAIL**



SECTION A-A D4-2
SCALE 6X

INSTALL THIS SIDE ONLY, AFTER FINISH:
AETC-1032 INSERT
NAS1149C0363R WASHER
NAS1635-3-8 SCREW

14 15
D3502-1 SUPPORT
MS21920-20 CLAMP (OR -21/-22)
D5123-7 RUBBER CUSHION
2 PL

D350-748-243
BENT TUBE

DEO ATTACHED

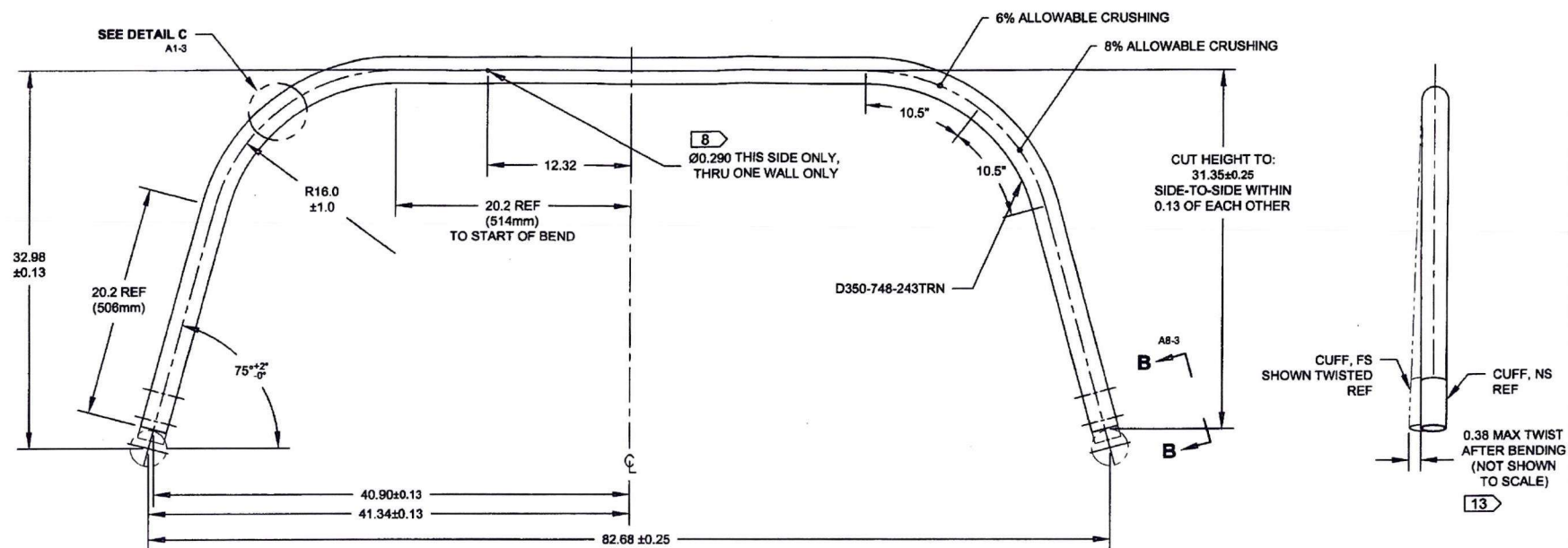
RELEASED

2015 MAR 18 4P

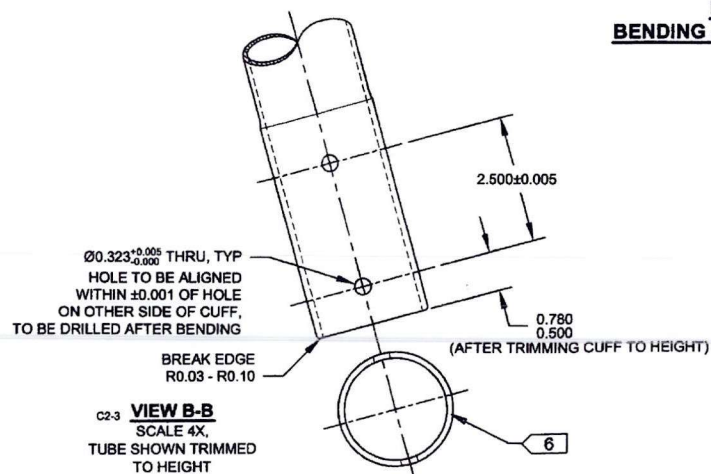
UNDER REVIEW

15/1/21 OK 9/16/21

DESIGN	<i>g</i>	DART AEROSPACE LTD	
DRAWN	<i>g</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D350-748-243	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	15.01.21	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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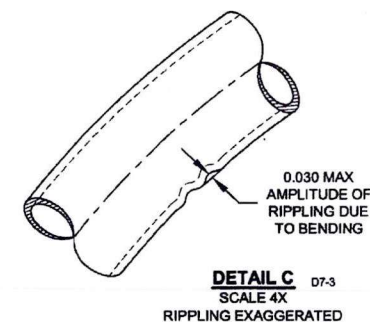
D350-748-243
BENDING AND DRILLING DETAIL 11



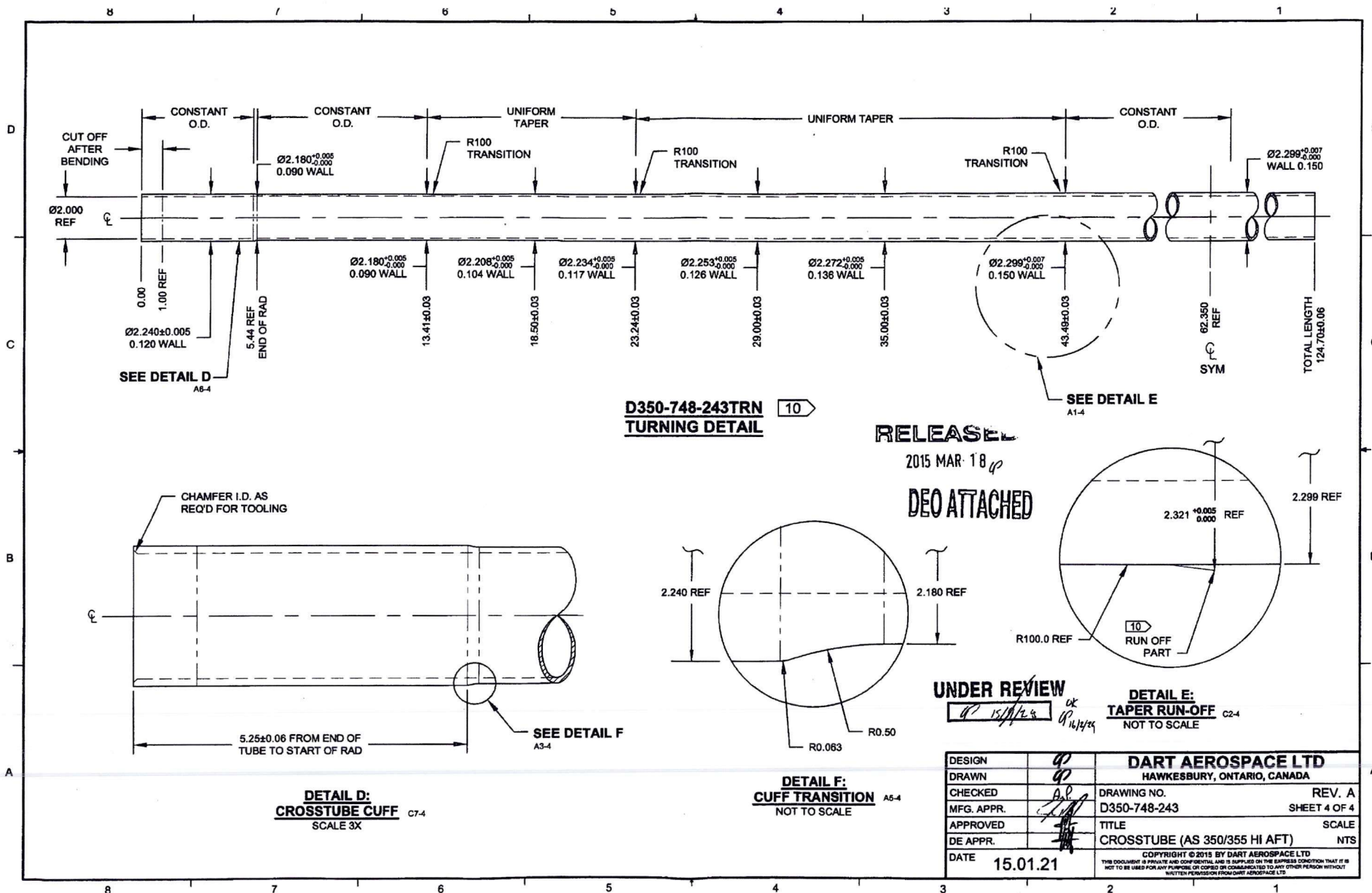
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2015 MAR 18

UNDER REVIEW

15/14/12



DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO. D350-748-243	REV. A SHEET 3 OF 4
MFG. APPR.	7/1/12	TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE NTS
DE APPR.	15.01.21	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
DATE	15.01.21	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DRAWING NO. D350-748-243	TITLE CROSSTUBE	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D350-748-243-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 15.11.18	DATE 15.11.18	DATE 16.02.19	DATE FEB 19 2016		DATE 2016.02.19		

AMEND NOTE 2 (SHEET 1) AS FOLLOWS:

- 2) FINISH: PREPARE SURFACE PER DART QSI 005 4.1.4
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 PAINT OUTSIDE PER DART QSI 005 4.2
 OR
 POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

RELEASED
 2016-02-26
EN 16-534 *[Signature]*

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042383



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO042383
PO Date: 1/24/19
Due Date: 1/30/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments: *revised*

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180864	D407-667-105	Fwd Crosstube - High 407 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** OUTSIDE SERVICE - CROSSTUBES Liquid Penetrant Inspection as per QSI 038 Or Level 2 Attach copy of NDT results to work order *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** OUTSIDE SERVICE - CROSSTUBES Liquid Penetrant Inspection as per QSI 038 Or Level 2 Attach copy of NDT results to work order	Firmed	-	1/30/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
2	188323	D350-748-203	ISSUE P/O TO SKY SERVICE: ISSUE P/O TO SKY SERVICE:	Firmed	-	1/30/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	184901			Firmed	-	1/30/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
Sub Total:							2	0	2		\$263.75



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042383



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	188322	D350-748-103	AS350 / AS355 Stainless Steel Fwd Crosstube : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKY SERVICE:	Firmed	-	1/30/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	188318		IX JAN 30 2019	Firmed	-	1/30/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	188321		IX JAN 30 2019	Firmed	-	1/30/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	188319		IX JAN 30 2019	Firmed	-	1/30/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
Sub Total:							4	0	4		\$527.50
4	189710	D412-664-203	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	1/30/19	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
Grand Total:											\$1,055.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/29/19 3:12 PM dart.tsimiklis.chrisoula



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO39047	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO042383
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

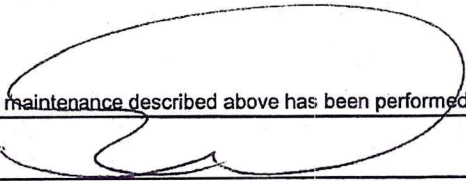
Work Required:

CARRY OUT NDT ON:

- ✓ 1 FWD CROSSTUBES , P/N# D407-667-105 , J/S# 180864 ✓
- ✓ 2 CROSSTUBES , P/N# D350-748-203 , J/S# 188323 , 184901 ✓
- ✓ 4 FWD CROSSTUBES , P/N# D350-748-103 , J/S# 188322 , 188318 , 188321 , 188319 ✓
- ✓ 1 AFT CROSSTUBES , P/N# D412-664-203 , J/S# R172997 (189710) ✓

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16						JAN 24 2019	 
NO CRACK FOUND							
PEN ZL-37, MPO23206, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO15030, UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: JAN 24 2019
Name: RAFIK MELIKJAN		